

Date: Friday, 5/25/2007 8:01:36 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ARM
Job Number : 32549	
Estimate Number : 10705	
P.O. Number : N/A	Part Number : D2012101
This Issue : 5/25/2007 S.O. No. : N/A	Drawing Number : D2012-101 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : C
Previous Run : 31481	Material : N/A
Written By : <u>Kim Johnston</u>	Due Date : 6/5/2007
Checked & Approved By : <u>07.05.28</u>	Qty: 10 Um: Each
Comment : Est Rev: 02.04.03 Added Inspect level 3 NG	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0500W035	304 RD Tube .500 x .035W
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Comment: Qty.: 2.1000 f(s)/Unit Total: 21.0000 f(s)
 Material: 304/316 Seamless SS tubing, 1/2" O.D. x .035" wall(M304TR0.500W.035)
 Identify as D2012-101
 Batch: M 104640 (6x) / M104598 (4x)

FF 07-06-26 10

2.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

(PTU)

1-Punch to length as per Dwg D2012-101 & template D2012-101T1

FF 07-06-26 10

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

SAD 07/07/05 (10)

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

En 07/07/05 (49)

5.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

BR/KL 07-07-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/07/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/07/05	2.0	1 part is 9° under 30° R.C: Material turned during punching.		cut off the punch on one end. Identify material i re-stock for a shorter stroke. No replacement.	SM 07/07/05	Er 07/07/05		

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 32549

Part Number: D2012101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

JS 07/07/09 (2)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

JS 07/07/09 (2)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

JS 07/07/10 (9)

Job Completion



JS 07/07/10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

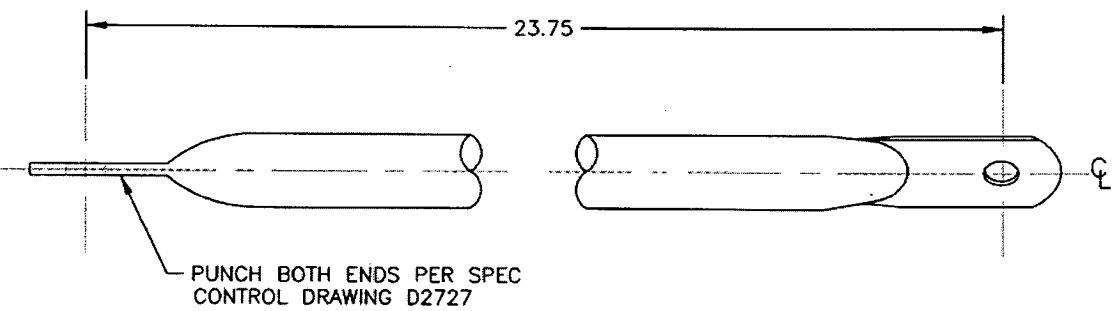
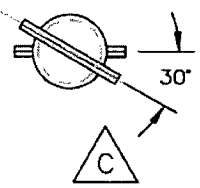
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
02.03.26

DESIGN	JB	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA		
CHECKED		APPROVED		DRAWING NO.	REV. C
DATE	02.03.26			D2012-101	SHEET 1 OF 1
			TITLE	ARM	SCALE
A		92.06.04		NEW ISSUE - DRAWN FROM D2012	NTS
B		98.04.28		ADDED TEMPLATE & SPEC CTRL DWG REDRAWN IN CAD	
C		02.03.26		ADD FINISH: CHANGE ANGLE TO MATCH B15015. PER NCR 641	



PUNCH BOTH ENDS PER SPEC
CONTROL DRAWING D2727

- NOTES:
1. MAKE PER TEMPLATE DT8067, (WAS DT2012-101)
 2. MATERIAL: AISI 304/316 STAINLESS STEEL TUBE $\varnothing 0.500 \times 0.035$ WALL
 3. FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
 4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 5. ALL DIMENSIONS ARE IN INCHES



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